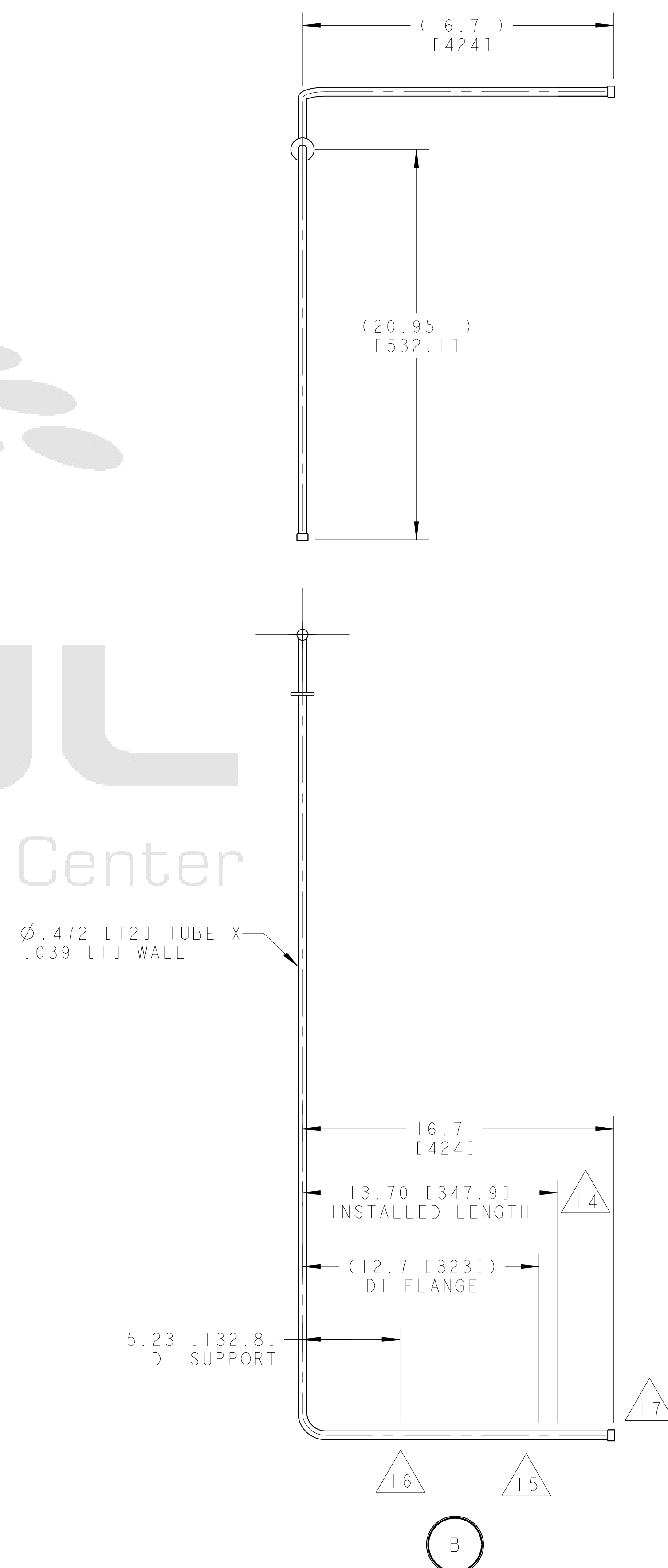
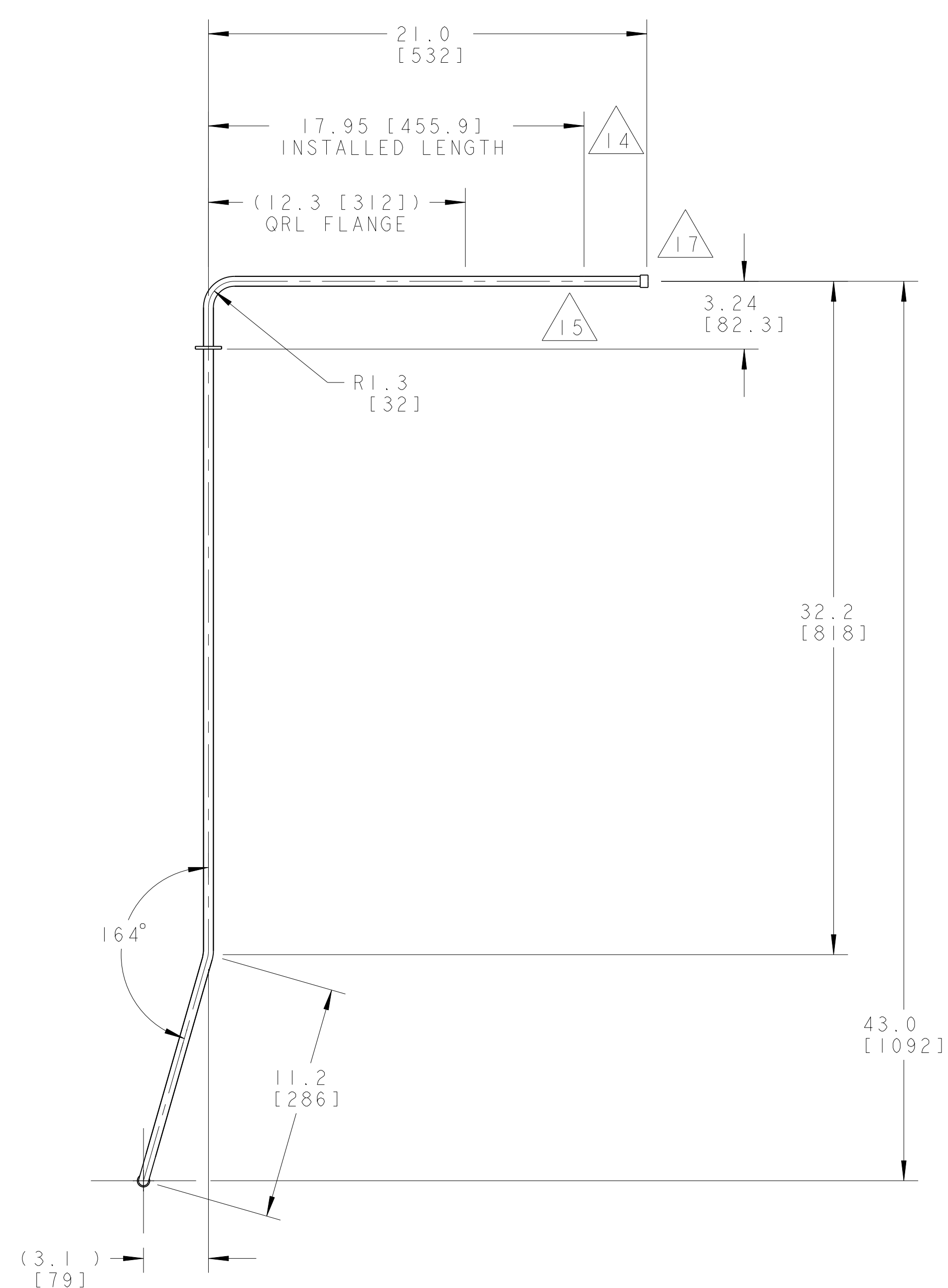
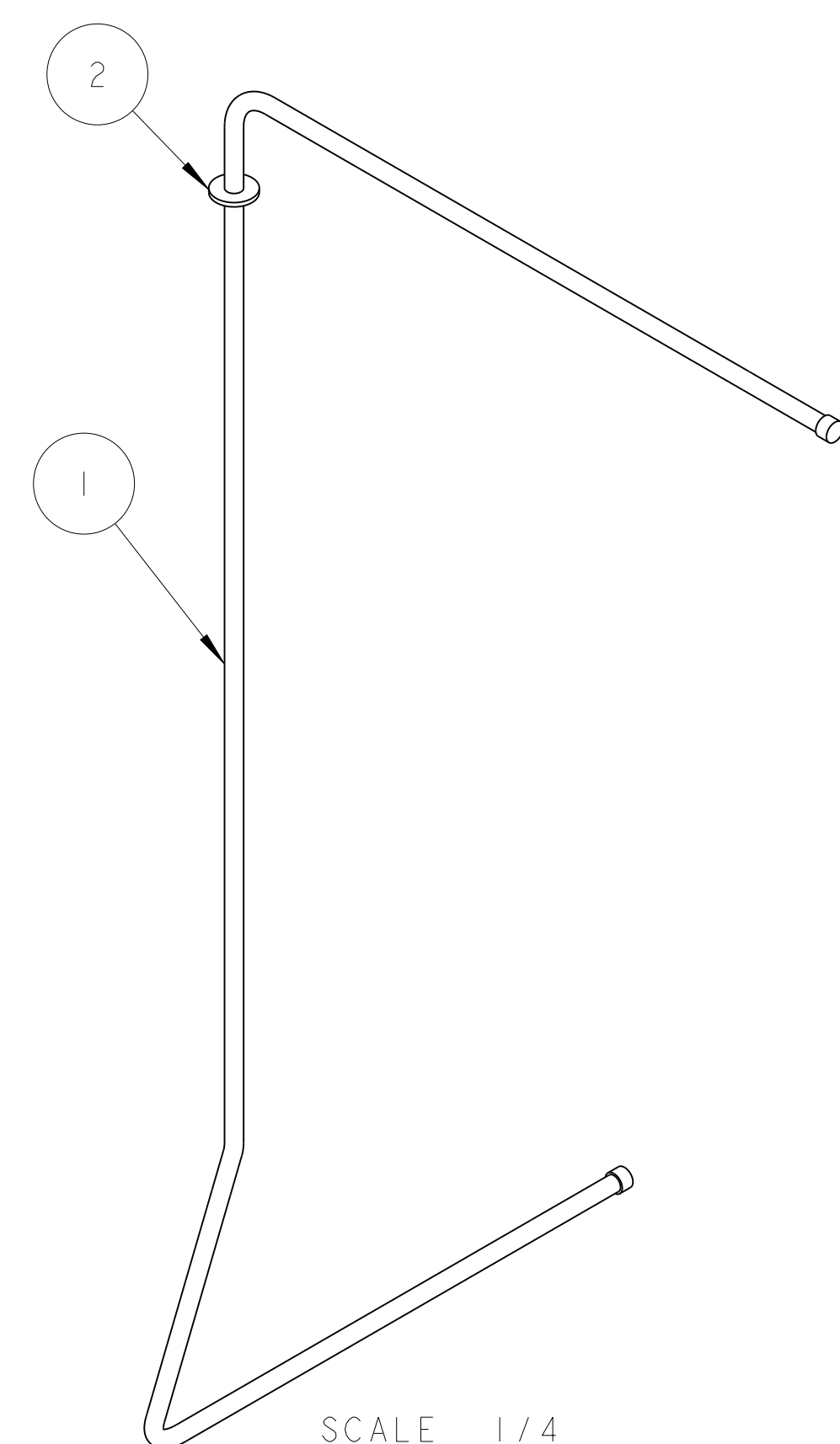


1. THIS IS A CRYOGENIC VACUUM COMPONENT.
2. WELDING PROCEDURE: PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
3. CLEANING PROCEDURE : PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
4. PACKAGING AND STORAGE PROCEDURE OF THE COMPONENTS:
PER VENDOR SPECIFICATION WITH LBNL APPROVAL.
5. DIMENSIONS AND TOLERANCING PER ANSI Y14.5M-1982.
UNITS ARE IN INCHES [mm] UNLESS OTHERWISE SPECIFIED.
6. USE OF SULFUR OR SILICONE BEARING OILS, LUBRICANTS,
OR COOLANTS ARE STRICTLY PROHIBITED.
7. USE OF RESIN OR RUBBER BONDED ABRASIVES UNDER POWER
IS STRICTLY PROHIBITED. USE VITREOUS BONDED ABRASIVES
ONLY.
8. VENDOR SUGGESTED CHANGES TO WELD PREPS; SUBJECT TO
LBNL APPROVAL.
9. FITTINGS MAY BE USED IN PLACE OF BENDS; SUBJECT TO LBNL APPROVAL.
10. VENDOR SUGGESTED CHANGES TO TOLERANCES TO FACILITATE
FABRICATION OR ASSEMBLY: SUBJECT TO LBNL APPROVAL.

1. REMOVE ALL THD BURRS AND REAM THE ENDS FOR CIRCULARITY AND CLEAN ENDS.
2. TUBE END SURFACE MUST BE PERPENDICULAR TO THE TUBE AXIS WITHIN $\pm .010$.
3. PERFORM ACCEPTANCE TESTS PER LBNL SPECIFICATION M989. (B)
4. A MARK DESIGNATING THE INSTALLED LENGTH WILL BE UTILIZED DURING FINAL INSTALLATION OF THE DEEDBOX ASSEMBLY. MARK, SCRIBE OR ETCH THIS LOCATION IN A PERMANENT MANNER, SUBJECT TO LBNL APPROVAL, TO AN ACCURACY OF 0.063".
5. PROVIDE A MINIMUM LENGTH OF 4.0" OF STRAIGHT, SMOOTH PIPE ON THE INDICATED SIDE OF THE INSTALLED LENGTH MARK FOR PIPE WELDING DURING FINAL INSTALLATION OF THE FEEDBOX ASSEMBLY.
6. PIPE MUST BE STRAIGHT AND SMOOTH (NO BUMPS) FOR 1.5" ON EITHER SIDE OF THE CENTER-PLANE OF THE SUPPORT.
7. CAP BOTH ENDS OF PIPE TO FACILITATE ACCEPTANCE TESTS. (B)




Ø.472 [12] TUBE X—
.039 [1] WALL

THIRD ANGLE PROJECTION

C	RLW	JPZ	17/6/04	ADD DFBX A IN TITLE LINE	
B	ARR	SPV	9/11/02	REVISED PIPE GEOMETRY. REVISED DRAWING NOTES 13, 16 & 17	
A	ARRH	SPV		INITIAL REVISIONS	
REV	DWG	CHK	ZONE	DATE	CHANGES

UNLESS OTHERWISE SPECIFIED							
TOLERANCES	<table border="1"> <tr> <td>X, X ± 0.1</td> <td>FRACTION ± 1/64</td> </tr> <tr> <td>X, XX ± 0.03</td> <td>Angles ± 1.00</td> </tr> <tr> <td>X, XXX ± 0.010</td> <td>FINISH 125 \sqrt{Ra}</td> </tr> </table>	X, X ± 0.1	FRACTION ± 1/64	X, XX ± 0.03	Angles ± 1.00	X, XXX ± 0.010	FINISH 125 \sqrt{Ra}
X, X ± 0.1	FRACTION ± 1/64						
X, XX ± 0.03	Angles ± 1.00						
X, XXX ± 0.010	FINISH 125 \sqrt{Ra}						
DO NOT SCALE PRINT							
THREADS ARE CLASS 2							
CHAMFER ENDS OF ALL SCREW THREADS 30°							
CUT ROUND, 1.5 THREAD RELIEF ON MACHINED THREAD							
BREAK EDGES .015 MAX. ON MACHINED WORK							
REMOVE BURRS, WELD SPLICER & LOCKE SCREW							
IN ACCORDANCE WITH ASME Y14.5M & B46.1							

2	-	1	FLANGE, SPIDER INTERFACE	SS 304L
1	-	1	TUBE, PER ASTM A269	SS 304L
ITEM	PART NO.	REQD	DESCRIPTION	MATERIAL
SHOP ORDERS			ERNEST ORLANDO LAWRENCE BERKELEY NATIONAL LABORATORY UNIVERSITY OF CALIFORNIA - BERKELEY	
ADD'L REQD	NO REQD	NO REQD	LHC IR FEEDBOX CRYOGENICS	
CON- FERENCE TAG	PROJ- ECT TAG	PROJ- ECT NUMBER	PIPE, CC3, DBX A	
DATE	DATE	DATE	MICROFILMED: _____ DWG. TYPE _____ SHOWN ON _____ SCALE: 7/32 _____ DWG. NO. _____ REV. _____	
PROJECT NAME	PROJECT DATE	PROJECT DATE	SHEET 1 OF 1 ASSEM DESIGN ACCT: 5ZLCF2 CATEGORY CODE: LH2030 2515086	
APPROV BY	DATE	DATE	PATENT CLEAR: _____ Jon Zbasnik/D. Virostek 01-Nov-02 Jon Zbasnik/D. Virostek 08-JUL-02	